

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025840**Date Inspected:** 11-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Trial Assembly Area

Caltrans and ABF have agreed to conduct visual inspection (VT) and magnetic particle inspection (MT) of welds as part of a special joint inspection program. In response to ZPMC NDT Inspection Notification Sheets (NWIT) #09705 for MT of the following:

This QA Inspector performed random VT and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date and provided a turnover to dayshift personnel for tracking of these welds. The members were identified as follows:

OBG Segment 13CW, SEG3015K. The weld designations reviewed were: 186, 187. No apparent VT or MT indications were observed.

OBG Segment 13BW, SEG3014V. The weld designations reviewed were: 103, 104. ZPMC personnel reported no apparent VT or MT indications were observed. No apparent VT indications were observed by this QA Inspector and no MT was performed by this QA Inspector.

OBG Segment 13CW, SEG3015K. The weld designations reviewed were: 230, 231. ZPMC personnel reported no apparent VT or MT indications were observed. No apparent VT indications were observed by this QA

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Inspector and no MT was performed by this QA Inspector.

OBG Segment 13BW, SEG3014B. The weld designations reviewed were: 123, 124, 233. ZPMC personnel reported no apparent VT or MT indications were observed. No apparent VT indications were observed by this QA Inspector and no MT was performed by this QA Inspector. Weld designations 146, 147, 154 were also listed on NWIT #09705 and ZPMC personnel reported no apparent VT or MT indications were observed. However, these welds had rough, irregular surfaces in and at the cope holes requiring grinding. Weld designation 155 had no weld at all. This QA Inspector rejected weld designations 146, 147, 154, 155 for VT based on the above.

In OBG Segment 13CW, SEG3015V, weld designations 111, 112, 014, 015, 016, 017, 018 were also listed on NWIT #09705 and ZPMC personnel reported no apparent VT or MT indications were observed. However, these welds had rough, irregular surfaces at the cope holes requiring grinding. This QA Inspector rejected weld designations 111, 112, 014, 015, 016, 017, 018 for VT based on the above.

In OBG Segment 13CW, SEG3015K, weld designations 193, 194 were also listed on NWIT #09705 and ZPMC personnel reported no apparent VT or MT indications were observed. However, these welds had rough, irregular surfaces at the cope holes requiring grinding and weld designation 193 showed an excavation 2mm to 3mm deep at the cope hole. This QA Inspector rejected weld designations 193, 194 for VT based on the above.

This QA Inspector observed an excavation approximately 15mm x 75mm x 7~8mm deep in the top of the flange of the floor beam at panel point 122, north (counterweight) side approximately 2 meters from the vertical plate.

This QA Inspector generated an Incident Report concerning the VT rejections noted above and informed ZPMC QC Xie Gen Lin.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
